

**Work Order ID- 66602**

Tuesday, February 22, 2011 1:36:17 PM



Page 1

Item ID: D3188-2M

Accept



Setup Start



Revision ID:

Stop



Item Name: SPACEPOD BODY RH

Start Date: 2/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date: 11-02-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3188

Rev F

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 13537

Description: D3188-2MBODY

SHIP: QTY (8) D2213 Spacers

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

*PL 11-02-22*

110

0.00



Receive &amp; Inspect for Damage &amp; Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

*PL 11-02-22 (1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66602**

Tuesday, February 22, 2011 1:36:17 PM

Page 2

Item ID: D3188-2M

Accept

Revision ID:

Item Name: SPACEPOD BODY RH

Start Date: 2/22/2011 Start Qty: 1.00

Required Date: 2/25/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Check for void spot and pins.

11 07 06 (7)

130

Identify as per dwg & Stock Location: *composites*

0.00



Packaging

Memo

0.00

Packaging

11 07 06

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11-07-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, February 22, 2011 1:36:24 PM

Page 1

Work Order ID: 66602

Parent Item: D3188-2M

Parent Item Name: SPACEPOD BODY RH

Start Date: 2/22/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New issue ecn882 06-11-30 EC  
 IPP rev B rev D dwg 07.03.07 ec  
 IPP rev C rev E dwg 07.04.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2213		Manufactured	No			100	Each	203.0000	8	8			
-------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

Insert

Location	Loc Qty	Loc Code
ST008	203	
30107	27	
30809	176	

D3188-2P		Purchased	No			110	Each	0.0000	1	1			
----------	--	-----------	----	--	--	-----	------	--------	---	---	--	--	--

Spacepod Body

3 66602

11-02-22

2/21/4/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**GENERAL NOTES:**

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.  
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A  
D3188-2 = N/A  
D3188-3 = N/A  
D3188-5 = N/A  
D3188-6 = N/A  
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

**RELEASED**  
2009-10-20

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5I/-6I/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	#	DRAWING NO.	REV. F
MFG. APPR.	#	D3188	SHEET 1 OF 11
APPROVED	#	TITLE	SCALE
DE APPR.	#	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

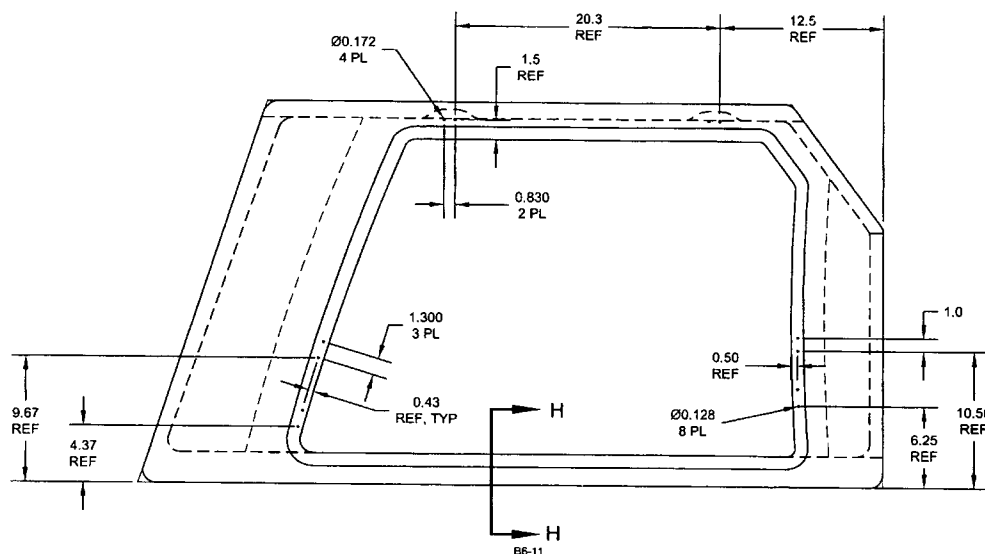
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3188-1 SPACEPOD BODY**  
MAKE FROM D3188-1M

**RELEASED**  
2009-10-20  
*MP*

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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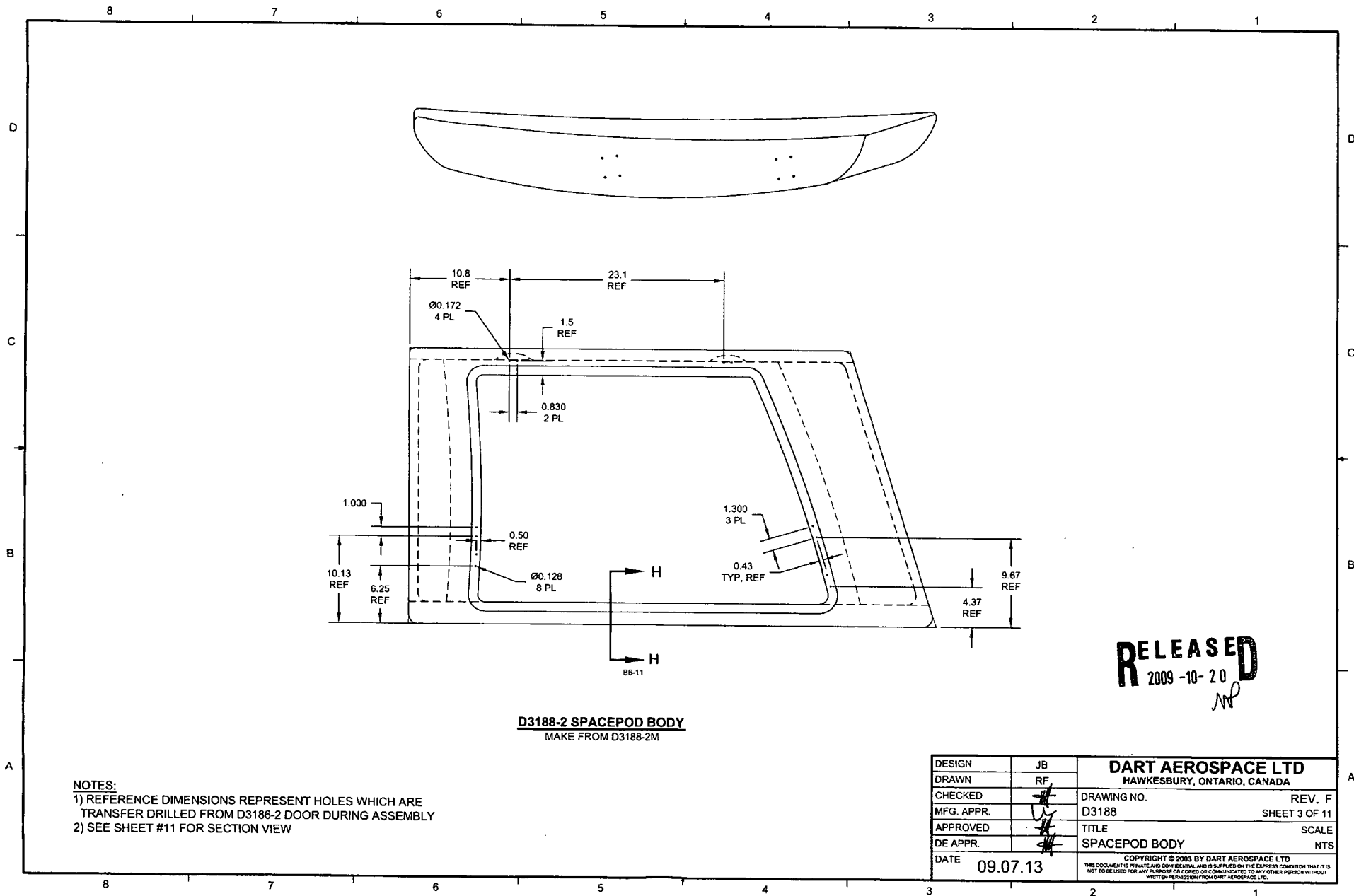
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



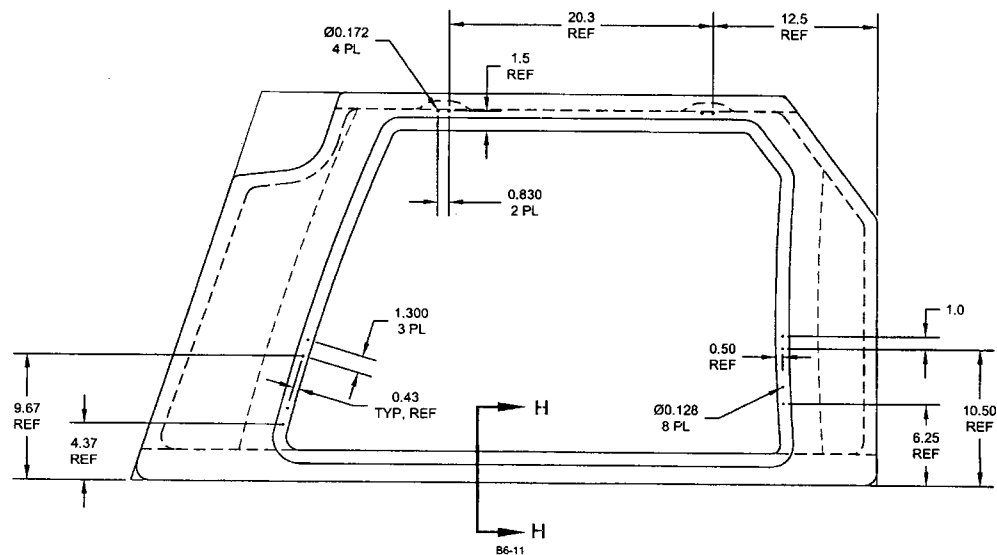
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries







**D3188-3 SPACEPOD BODY**  
MAKE FROM D3188-3M

**RELEASED**  
2009-10-20

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
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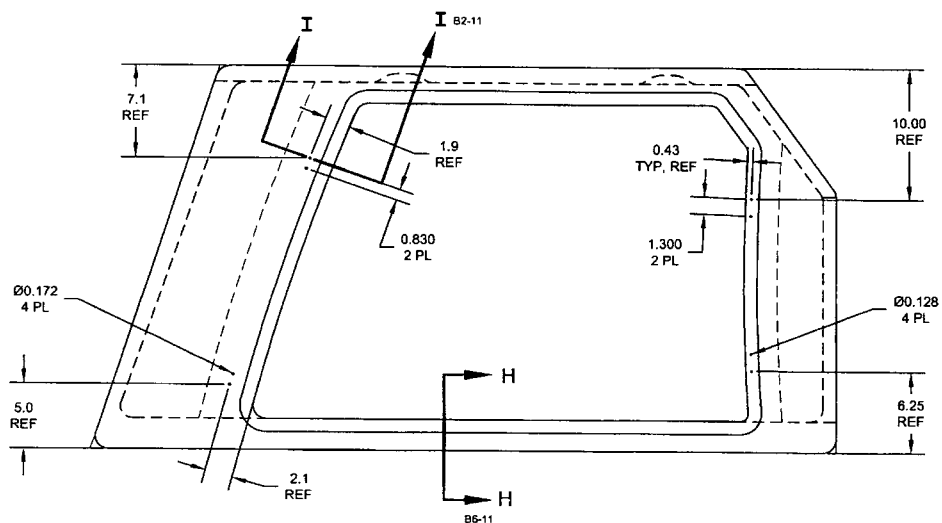
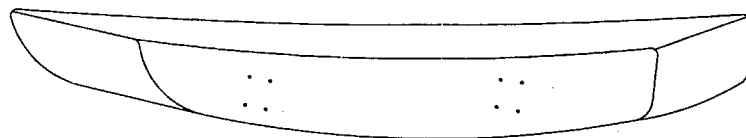
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3188-5 SPACEPOD BODY**  
MAKE FROM D3188-1M

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

**RELEASED**  
2009-10-20

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 5 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

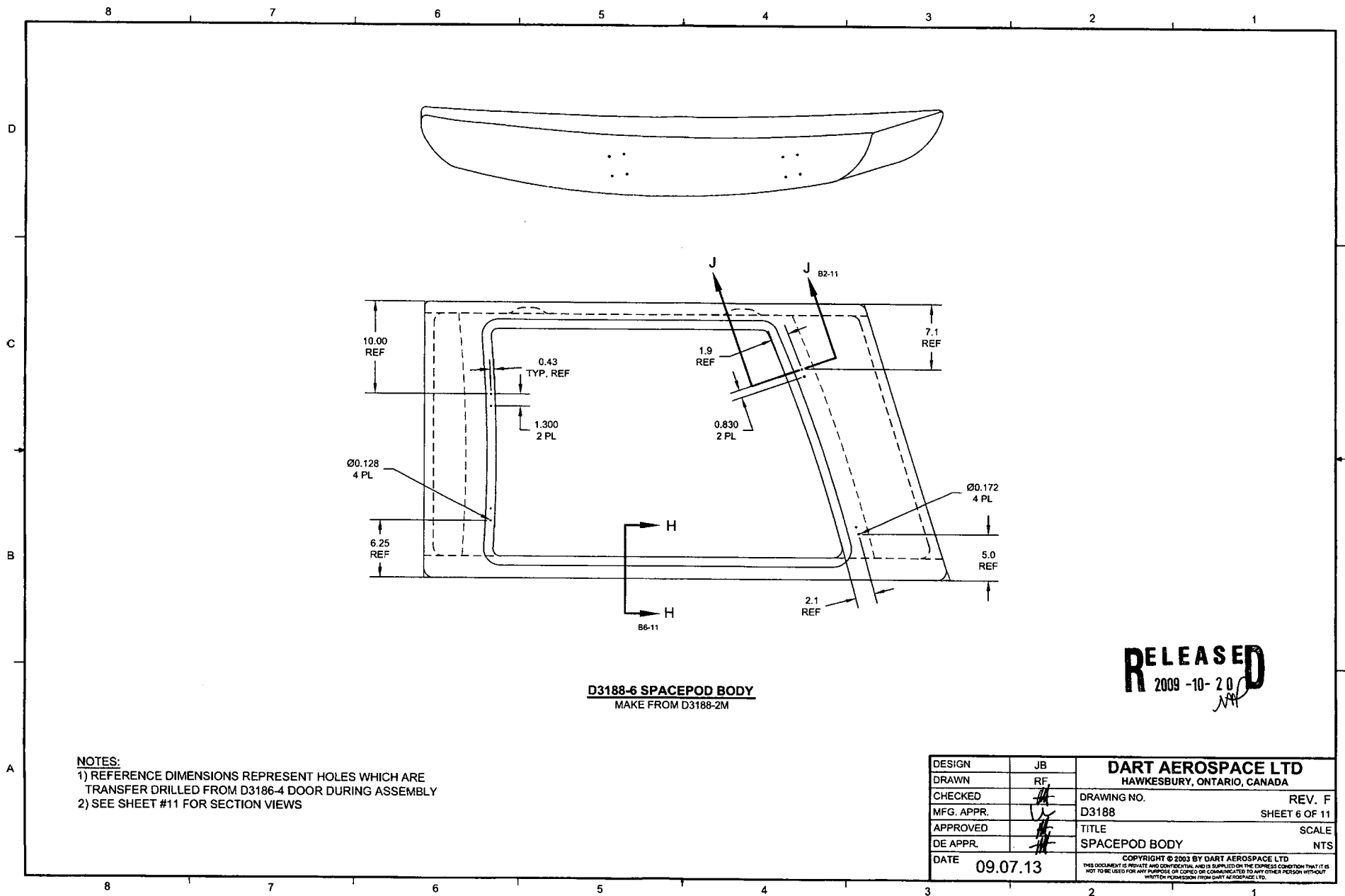
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





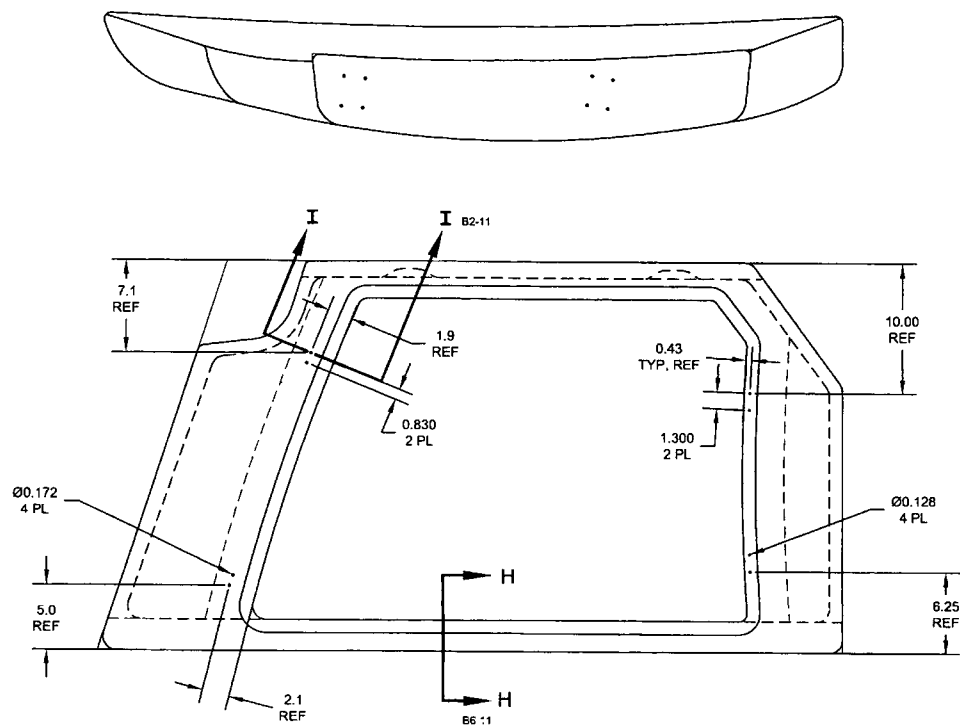
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3188-7 SPACEPOD BODY**  
MAKE FROM D3188-3M

**NOTE:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

**RELEASED**  
2009-10-20

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 7 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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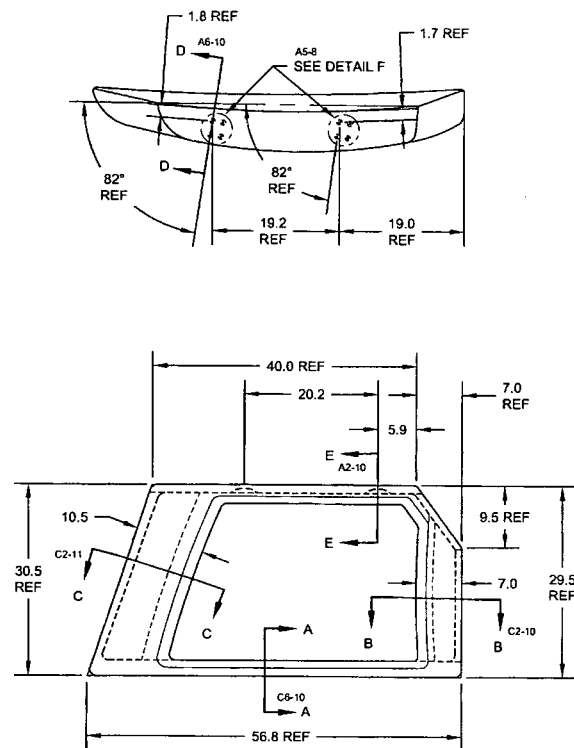
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

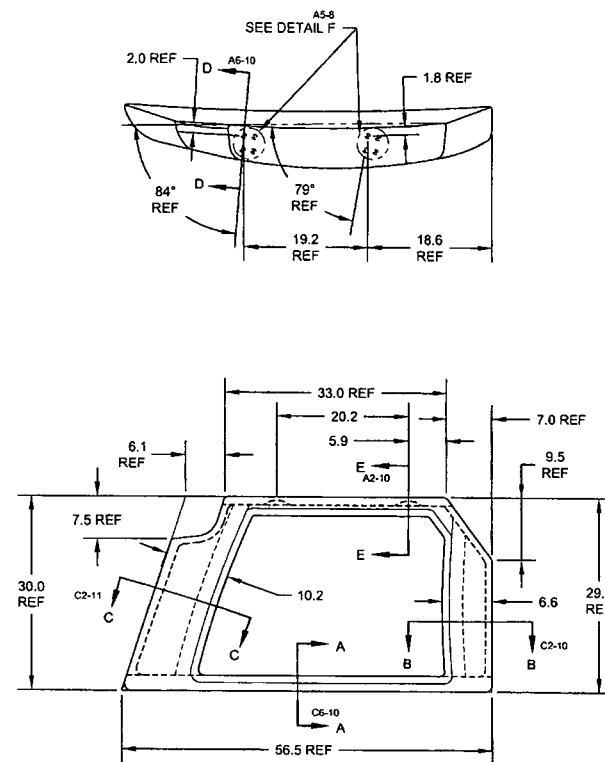
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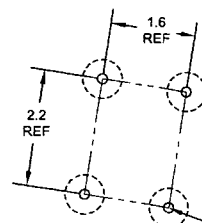
**NOTE:** Date & initial all entries



**D3188-1M SPACEPOD BODY**



**D3188-3M SPACEPOD BODY**







**DETAIL F**

INSTALL  
D2213 SPACER  
8 PL  
SEE SECTION D-D  
A5-10

**D3188-1M/-3M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

**RELEASED**  
2009-10-20

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 8 OF 11
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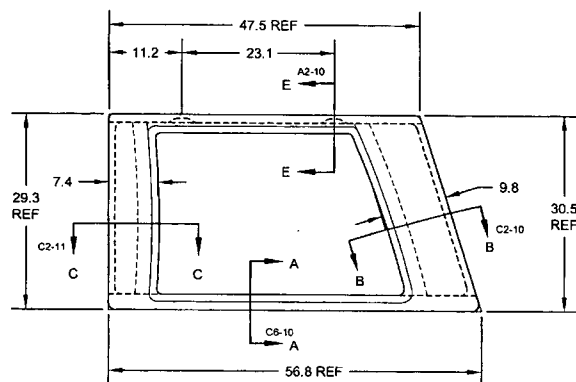
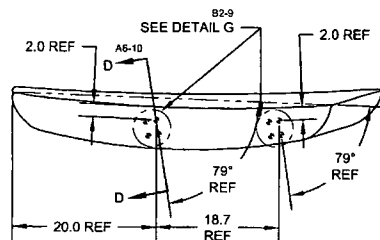
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

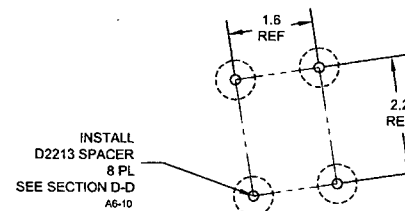
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3188-2M SPACEPOD BODY**



**DETAIL G** D6-9

**RELEASED**  
2009-10-20

**D3188-2M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>RF</del>	DRAWING NO.	REV. F
MFG. APPR.	<del>RF</del>	D3188	SHEET 9 OF 11
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	SPACEPOD BODY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

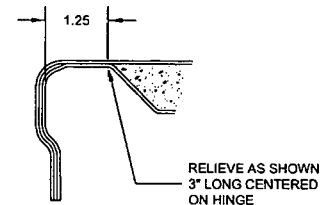
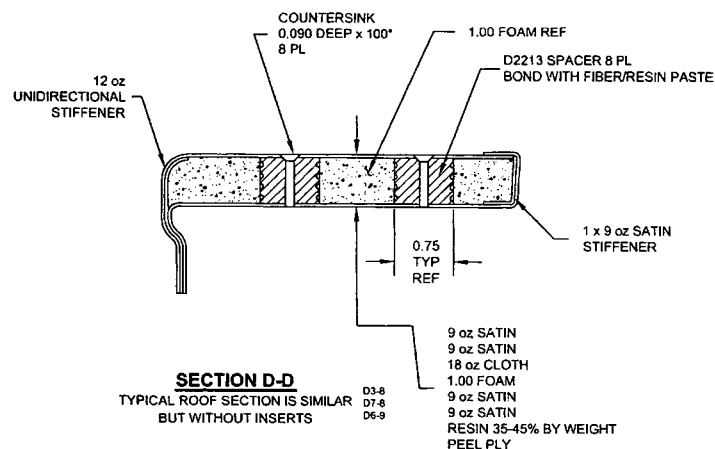
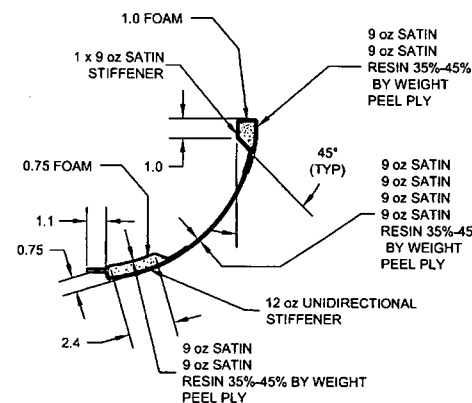
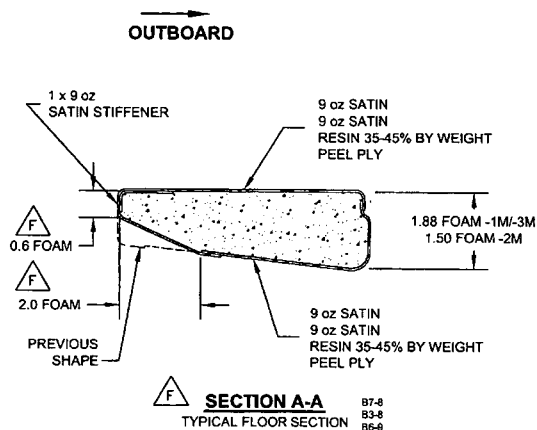
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**RELEASED**  
2009-10-27

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>RF</del>	DRAWING NO.	REV. F
MFG. APPR.	<del>RF</del>	D3188	SHEET 10 OF 11
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

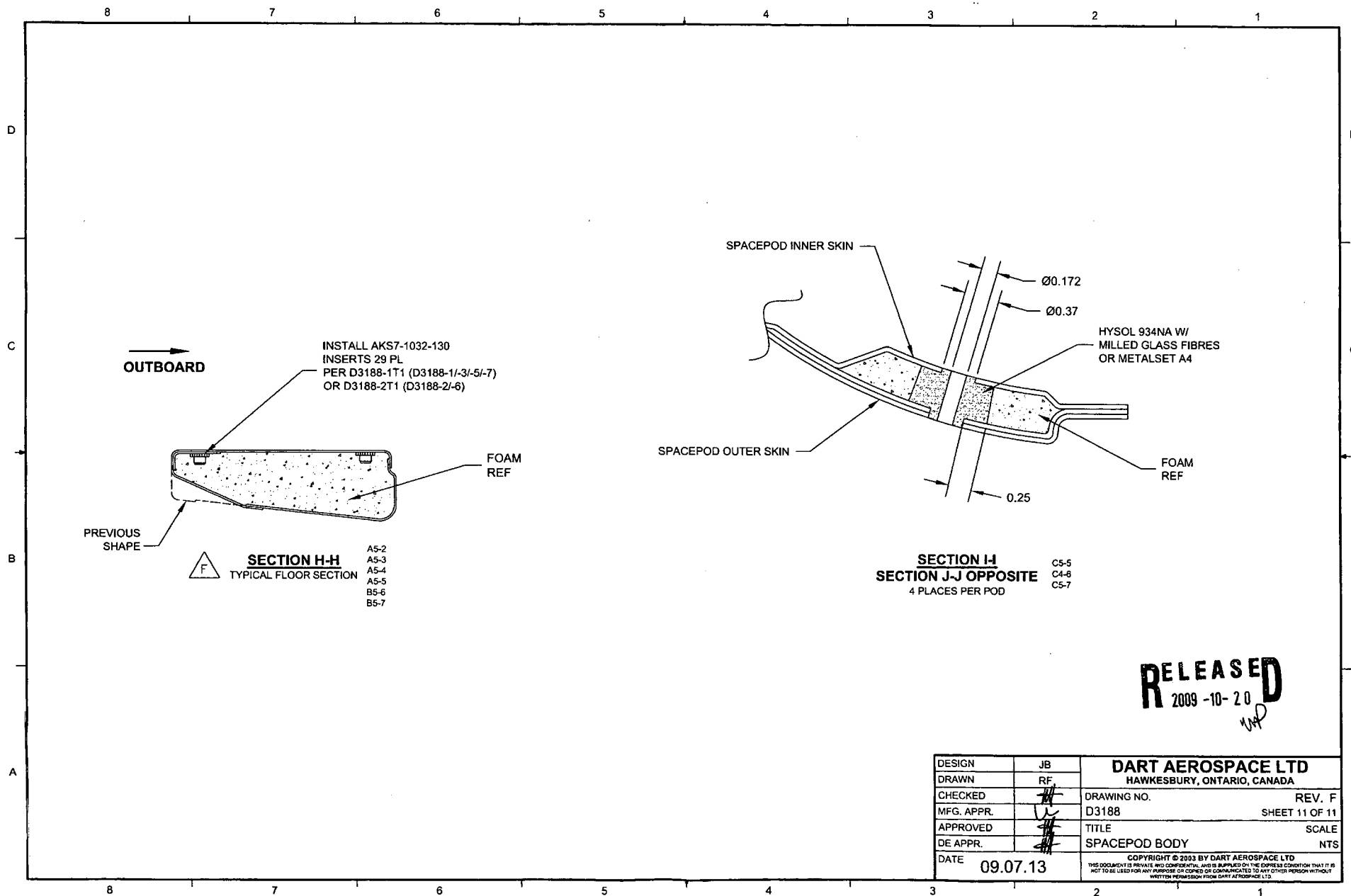
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	38071
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Fedex Ground Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
15/04/2011	22/02/2011	16857	Brigitte Golden		PO135374		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0071	Line 4 D31882P, Spacepod Body RH B66602 U de M : Each Dwg. D3188 Rév.: F  <div><div>No. série</div><div>No. lot</div><div>B66602</div><div>31896</div></div>			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust.    ☐ Adm.    ☐ Quality    ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Mardi, 2011-02-22 17:22:36  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: SPACEPOD BODY RH
Numéro Job	: 31896	Numéro Article	: DKC134-0071
Numéro Soumission	: 3763	Numéro Dessin	: D3188
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2011-02-22 No. B.V. :	Révision dessin	: F
Prsht Rev.	: NC	Matériel	: Fibre 7781 et résine 411-350
Prem. fois	: - - - Type :	Date Dûe	: 2011-03-01 Qté: 1 Udm: UNITE
Job précédente	: 31895		
Écrit par	: _____		
Vérifié & Approuvé par	: _____		
Commentaires	: N° de pièce Client: D3188-2		

**B 66602**

Process Sheet Rév.: 03 changer le sikkens AAC1390 pour le P15-3  
(AAC1492), enlever le AAC1617, changer le freekote 44-NC pour le  
Wolo

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AAC1616	N° 83634, Frekote Loctite Wolo
-----	---------	--------------------------------

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)  
N° 83634, Frekote Loctite Wolo # de Lot: \_\_\_\_\_

2.0	PRÉPARATION	Préparation du moule
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule selon IF134-0020.

Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

3.0	AC0883	Tissu à délaminer Release ply B
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Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)

4.0	AC0884	Wrightlon 5200 Bleu P3
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Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)

5.0	AC0885	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

6.0	AC0943	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)










7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
-----	---------	---

Commentair Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s)  
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: **1-28776-2**

Date: Mardi, 2011-02-22 17:22:36  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: SPACEPOD BODY RH	
Numéro Job: 31896		Numéro Article: DKC134-0071	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
8.0	AMB0349	Fiberglass 12 oz Unidirectional	
Commentair Qty.: 0.80 VERGE(s)/Unit Total: 0.80 VERGE(s) Fiberglass 12 oz Unidirectional N° de Lot: 1-22549-1			
9.0	AMB0213	WR1850 Roving 18oz. x 50"	
Commentair Qty.: 0.350 KILOGRAMME(s)/Unit Total: 0.350 KILOGRAMME(s) WR1850 Roving 18oz. x 50" N° de Lot: 1-28278-1			
10.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Commentair Qty.: 4.0000 ROULEAU(s)/Unit Total: 4.0000 ROULEAU(s)			
11.0	PREP-GENERAL	Préparation du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs  Tailler les tissus selon IF134-0020.  Date: 11-03-11 Sceau: 			
12.0	AMB0286	Catalyst N° DDM-9	
Commentair Qty.: 0.0640 GALLON(s)/Unit Total: 0.0640 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-27839-1			
13.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 2.000 LITRE(s)/Unit Total: 2.000 LITRE(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-30286-1			
14.0	AAC1540	Fibre de verre Miapoxy 66	
Commentair Qty.: 0.0040 GALLON(s)/Unit Total: 0.0040 GALLON(s) Fibre de verre Miapoxy 66 N° de Lot: 1-7046-1			
15.0	PREP-GENERAL	Préparation du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  Laminer la 1ère coquille selon IF134-0020.  Date: 16/03/11 Sceau:   			
16.0	AMB0355	ATC core-cell A500 plain 4'x8' 1" thick	
Commentair Qty.: 0.750 FEUILLE(s)/Unit Total: 0.750 FEUILLE(s) ATC core-cell A500 plain 4'x8' 1" thick N° de Lot: 1-6773-2 1-26978-2			
17.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 0.200 LITRE(s)/Unit Total: 0.200 LITRE(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-30286-1			

Date: Mardi, 2011-02-22 17:22:36  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 31896

Nom Dessin: SPACEPOD BODY RH  
Numéro Article: DKC134-0071

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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18.0	AMB0286	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0064 GALLON(s)/Unit Total: 0.0064 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

19.0	AAC1611	Polybond B46F
------	---------	---------------

Commentair Qty.: 0.010 KIT(s)/Unit Total: 0.010 KIT(s)  
Polybond B46F N° de Lot: 1-27795-1

20.0	TAILLAGE	Faire le taillage du matériel
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Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs

Tailler et ajuster les Foam Core selon IF134-0020.

Date: 18-3-11 Sceau:



21.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 0.300 LITRE(s)/Unit Total: 0.300 LITRE(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-30286-1

22.0	AMB0286	Catalyst N° DDM-9
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Commentair Qty.: 0.0096 GALLON(s)/Unit Total: 0.0096 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

23.0	FINITION	Finition Générale
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Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Sceller les foam core selon IF134-0020.

Date: 21/03/11 Sceau:



24.0	PERCAGE	Perçage de trous
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Percer les foam core selon IF134-0020.

Date: 21/03/11 Sceau:



25.0	AAC1611	Polybond B46F
------	---------	---------------

Commentair Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)  
Polybond B46F N° de Lot: 1-27795-1

Date: Mardi, 2011-02-22 17:22:36

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 31896

Numéro Article: DKC134-0071

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

26.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Installer les foam core selon IF134-0020.

Date: 23/03/11 Sceau:



27.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Commentair Qty.: 0.050 GALLON(s)/Unit Total : 0.050 GALLON(s)

N° P-15-3, Adtech Micro Ultra Filler

# de Lot: 1-29667-1

28.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Usiner les foam core selon IF134-0020.

Date: 23/03/11 Sceau:



29.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.600 KILOGRAMME(s)/Unit Total : 1.600 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-30286-1

30.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0536 GALLON(s)/Unit Total : 0.0536 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

31.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Laminer les plis de 9oz selon IF134-0020.

Date: 23/03/11 Sceau:



32.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire le taillage selon IF134-0022.

Date: 24-3-11 Sceau:





Date: • Mardi, 2011-02-22 17:22:36

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 31896

Numéro Article: DKC134-0071

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

33.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0144 GALLON(s)/Unit Total: 0.0144 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

34.0 AAC1540 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total: 0.0420 GALLON(s)  
Fibre de verre Miapoxy 66 N° de Lot: 1-7046-1

35.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.



Commentair Qty.: 0.450 KILOGRAMME(s)/Unit Total: 0.450 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-30286-1

36.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run: 0.9167Hrs

Faire le laminage des derniers plis 9oz selon IF134-0020.

Date: 23/03/11 Sceau:  

37.0 AAC1610 Spacer N° D2213

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)  
Spacer N° D2213 N° de Lot: 1-30231-1

38.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs

Faire l'assemblage des inserts selon IG 0097.

Date: 28-3-11 Sceau: 

39.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.5000 UNITE(s)/Unit Total: 0.5000 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-29624-2

40.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase


Commentair Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)  
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 129177-3

41.0 ~~PREP GENERAL~~ *Finition* ~~Préparation du matériel~~ *Finition générale*



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

*Faire les réparations de finitions selon IG 0008.*  
~~Préparer la pièce selon IG 0008.~~

 *B.C. 21/3/2011*

Quantité: 1 Date: 1-4-11 Sceau: 

Date: Mardi, 2011-02-22 17:22:36

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 31896

Numéro Article: DKC134-0071

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

49.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage selon IG 0057.



Date: 15 avril Sceau: \_\_\_\_\_